

W/O: 83451

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2571 PAR #: _____ Fault Category: Machining NCR: Yes No DQA: Not Date: 12/05/28
 Resolution: _____ Disposition: Scrap QA: N/C Closed: OK Date: 12/5/28

NCR: 12-1444

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12.05.14	1W	2 holes are over sized by 0.007". Saddle-to- skid holes. R.C. drill plunge into the part.	<u>U</u> <u>12/05/17</u>	SCRAP <u>12.05.14</u> replace Batch# <u>81994</u>	<u>OK</u> <u>12/05/14</u>	<u>OK</u> <u>12.05.14</u>	<u>U</u> <u>12/05/17</u>	<u>OK</u> <u>12/05/17</u>
				<u>fix the skid holes</u>	<u>OK</u> <u>12/05/17</u>			

NOTE: Date & initial all entries

Work Order ID 83451

83451

Page 2

Wednesday, April 18, 2012 8:43:01 AM

Item ID: D2571

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, Fwd Out 205

Start Date: 4/18/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 4/25/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC8- Inspect parts - second check

0.00

SL 12-05-17

130

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

12- 16 12:52

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150

Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

11-45

3200F

12:15

12x 4 12/6/22

m121134

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83451

Wednesday, April 18, 2012 8:43:01 AM

83451

Page 3

Item ID: D2571 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Fwd Out 205
 Start Date: 4/18/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 4/25/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				12	0	12-5-22	
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>432</u> Memo	0.00 0.00				12x		50 12-5-22	
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						12/5/23 MLJ 12/05/22	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, April 18, 2012 8:43:05 AM

Page 1

Work Order ID: 83451

83451

Parent Item: D2571

D2571

Parent Item Name: Saddle, Fwd Out 205

Start Date: 4/18/2012

Required Date: 4/25/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: 102.10.02Re-format; Change to Dwg Rev. D & incorporated
D2572KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-007		Manufactured	No			100	Each	44.0000	1	12			
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D6101-007

**

5.2 12/05/11

Saddle Billet

Location

Loc Qty

Loc Code

MAT042

44

79875

16

→ 81994

28

12.0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	03457
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		.450	.440	.441	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.500	.502	.500	.502		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.499	.499	.500	.499		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.566	.567	.568	.567		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.127	.124	.123	.124		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.251	.251	.251	.251		
S	0.115	0.135		.130	.131	.131	.130		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.958	2.960	2.960	2.960		
V	0.230	0.250		.240	.238	.239	.238		
W	0.115	0.135		.125	.120	.122	.121		
X	0.308	0.313		.309	.309	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.364	.367	.367	.367		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.625	.625	.625		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.247	.246	.248	.245		
AE	1.375	1.395		1.389	1.3873	1.388	1.388		
AF	0.115	0.135		.131	.133	.135	.135		
AG	0.240	0.280		.260	.255	.255	.255		
AH	0.240	0.260		.248	.248	.249	.248		
AI	2.000	2.020		2.000	2.0016	2.0024	2.0025		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	AK
Date:	12/05/12

Audited by:	JL
Date:	12-05-14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 83451
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	16	17	18	By	Date
A	0.438	0.443		.441	.440	.440	.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.500	.500	.500	.501		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.499	.499	.497	.499		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.567	.567	.565	.566		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.124	.125	.125	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.251	.252	.251	.250		
S	0.115	0.135		.128	.129	.129	.129		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.236	.235	.236	.234		
W	0.115	0.135		.120	.120	.120	.120		
X	0.308	0.313		.309	.310	.309	.309		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.369	.368	.365	.367		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.624	.625	.626		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.245	.244	.246	.248		
AE	1.375	1.395		1.3895	1.391	1.389	1.3878		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.255	.255	.266		
AH	0.240	0.260		.247	.245	.246	.249		
AI	2.000	2.020		2.0046	2.0051	2.0033	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	gry
Date:	12/05/13

Audited by:	JL
Date:	12-05-14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order: 83451
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	#9	#10	#11	#12	By	Date
A	0.438	0.443		.440	.440	.440	.440		.440
B	1.745	1.755		1.750	1.750	1.750	1.750		1.750
C	3.495	3.505		3.500	3.500	3.500	3.500		3.500
D	1.745	1.755		1.750	1.750	1.750	1.750		1.750
E	7.990	8.010		8.000	8.000	8.000	8.000		8.000
F	0.490	0.510		.500	.500	.500	.501		.505
G	0.257	0.262		.259	.259	.259	.259		.259
H	0.375	0.380		.377	.377	.377	.377		.377
I	0.490	0.510		.500	.501	.500	.499		.500
J	1.174	1.184		1.179	1.179	1.179	1.179		1.179
K	0.558	0.578		.568	.569	.568	.567		.568
L	1.174	1.184		1.179	1.179	1.179	1.179		1.179
M	1.490	1.500		1.495	1.495	1.495	1.495		1.495
N	2.495	2.505		2.500	2.500	2.500	2.500		2.500
O	3.869	3.879		3.874	3.874	3.874	3.874		3.874
P	0.115	0.135		.125	.126	.126	.125		.124
Q	0.115	0.135		.135	.135	.135	.135		.135
R	0.240	0.260		.251	.251	.251	.250		.250
S	0.115	0.135		.129	.129	.130	.133		.133
T	0.178	0.198		.188	.188	.188	.188		.188
U	2.940	2.980		2.960	2.960	2.960	2.960		2.960
V	0.230	0.250		.237	.238	.238	.240		.240
W	0.115	0.135		.121	.119	.117	.122		.120
X	0.308	0.313		.309	.310	.310	.316		.316
Y	0.760	0.765		.760	.760	.760	.760		.760
Z	0.352	0.372		.366	.366	.366	.366		.366
AA	0.470	0.530		.500	.500	.500	.500		.500
AB	0.615	0.635		.623	.625	.625	.625		.625
AC	0.053	0.073		.063	.063	.063	.063		.063
AD	0.240	0.260		.247	.246	.246	.248		.245
AE	1.375	1.395		1.3892	1.391	1.390	1.3857		1.387
AF	0.115	0.135		.135	.135	.135	.135		.135
AG	0.240	0.280		.265	.260	.260	.260		.260
AH	0.240	0.260		.247	.248	.247	.250		.248
AI	2.000	2.020		2.0036	2.006	2.0048	2.0002		2.0004
AJ	0.023	0.043		.033	.033	.033	.033		.033
Accept/Reject									

Measured by:	aml
Date:	12/05/14

Audited by:	JL
Date:	12-05-14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED

05.12.06

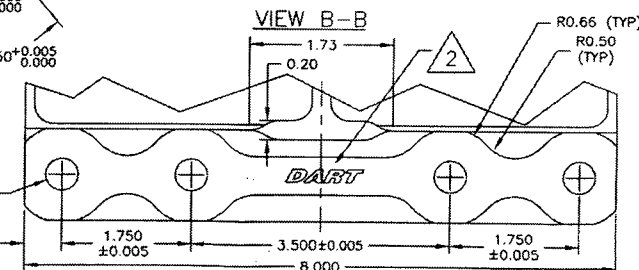
NOTES

MATERIAL: 7075-T7351 (Q0-A-250/12) (REF DART SPEC. D6102-001)
 FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 BREAK ALL SHARP EDGES 0.010 TO 0.020
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C)

E

VIEW B-B



E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	05.07.13	DRAWING NO. D2571
		TITLE OUTER FWD SADDLE
		REV. E SHEET 1 OF 1 SCALE 2:3

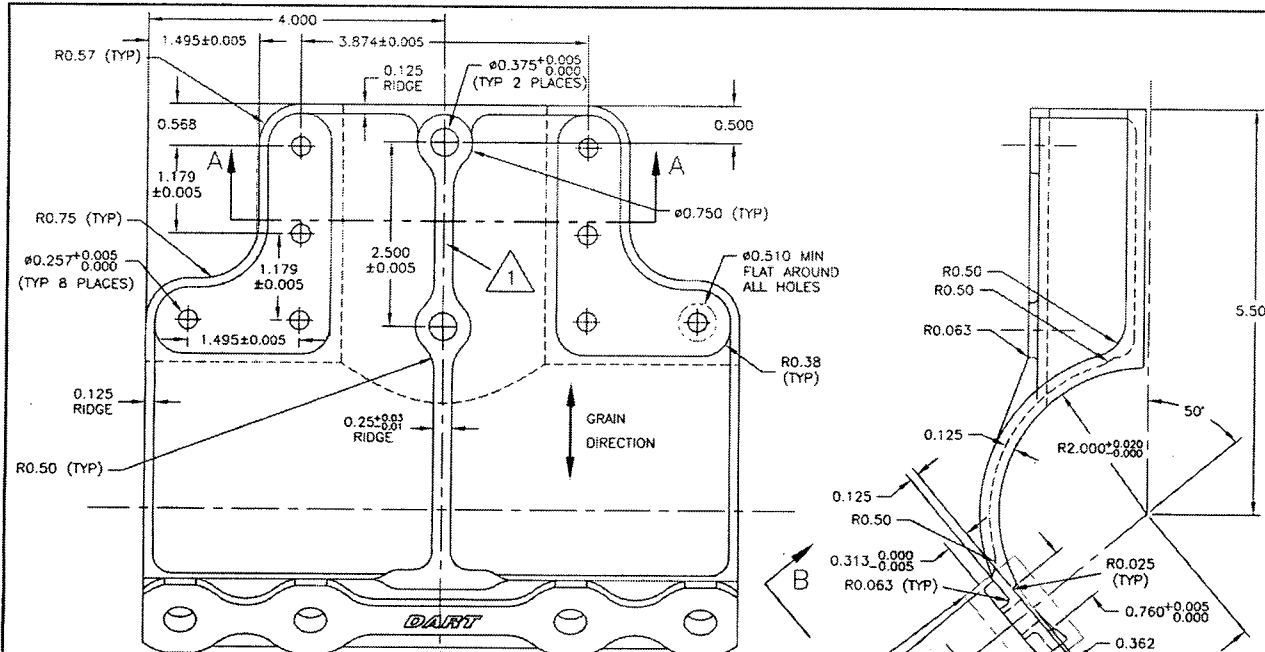
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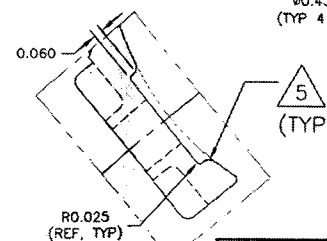
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 MARKHAM, ONTARIO, CANADA

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 NO. 83451 MLJ

12/04/18

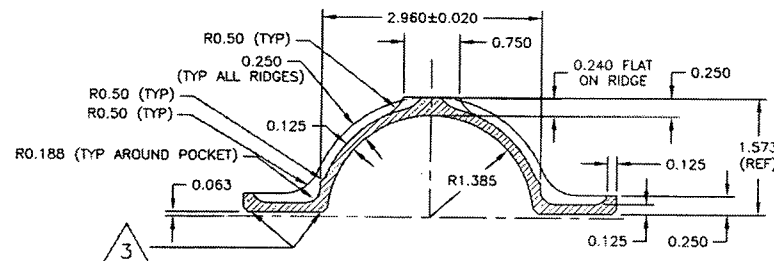


DETAIL C



DETAIL C
 SCALE 4:3

SECTION A-A



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries